

Work Order ID 70227

Wednesday, June 01, 2011 8:11:51 AM



Page 1

Item ID: D2493

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop Assembly

Start Date: 6/1/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-06-01

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2493

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2493.

ES 11/07/22 (7)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 01 22 (7)

120

Identify as per dwg & Stock Location: 223

0.00



Packaging

Memo

0.00

Packaging

11/11/22 SP 72

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/22

ME

11-07-22

Dart Aerospace Ltd

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Picklist Print

Wednesday, June 01, 2011 8:11:47 AM

Page 1

Work Order ID: 70227

Parent Item: D2493

Parent Item Name: Patient Stop Assembly





Start Date: 6/1/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C03.01.17 Reformat; Incorporated D2492 KJ/RF IPP Rev:D
10.09.24 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2492 		Manufactured	No			100	Each	0.0000	1	4			
Patient Stop D2444 		Manufactured	No			100	Each	0.0000	2	8			
Pip Pin Assembly MS27039-1-07 		Purchased	No			100	Each	146.0000	2	8			
Screw													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST291		146							
				18106		146							
NAS1149D0363J 		Purchased	No			100	Each	2,460.000	2	8			
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST298		2460							
				116583		460							
				117291		1000							
				117505		500							
				117601		500							

B55551

(72)

B70286

(148)

EP 5/11/07/22

EP 5/11/07/22

EP 5/11/07/22

14

EP 5/11/07/22

14

Dart Aerospace Ltd

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Page 2

Work Order ID: 70227



Parent Item: D2493

Parent Item Name: Patient Stop Assembly

Start Date: 6/1/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

100

Each

2,587.000

2

8



Nut

Signature
6/1/07/22

Location

Loc Qty

Loc Code

ST300

2587

116391

11

116540

110

116549

766

117441

800

117601

400

117885

500

14

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

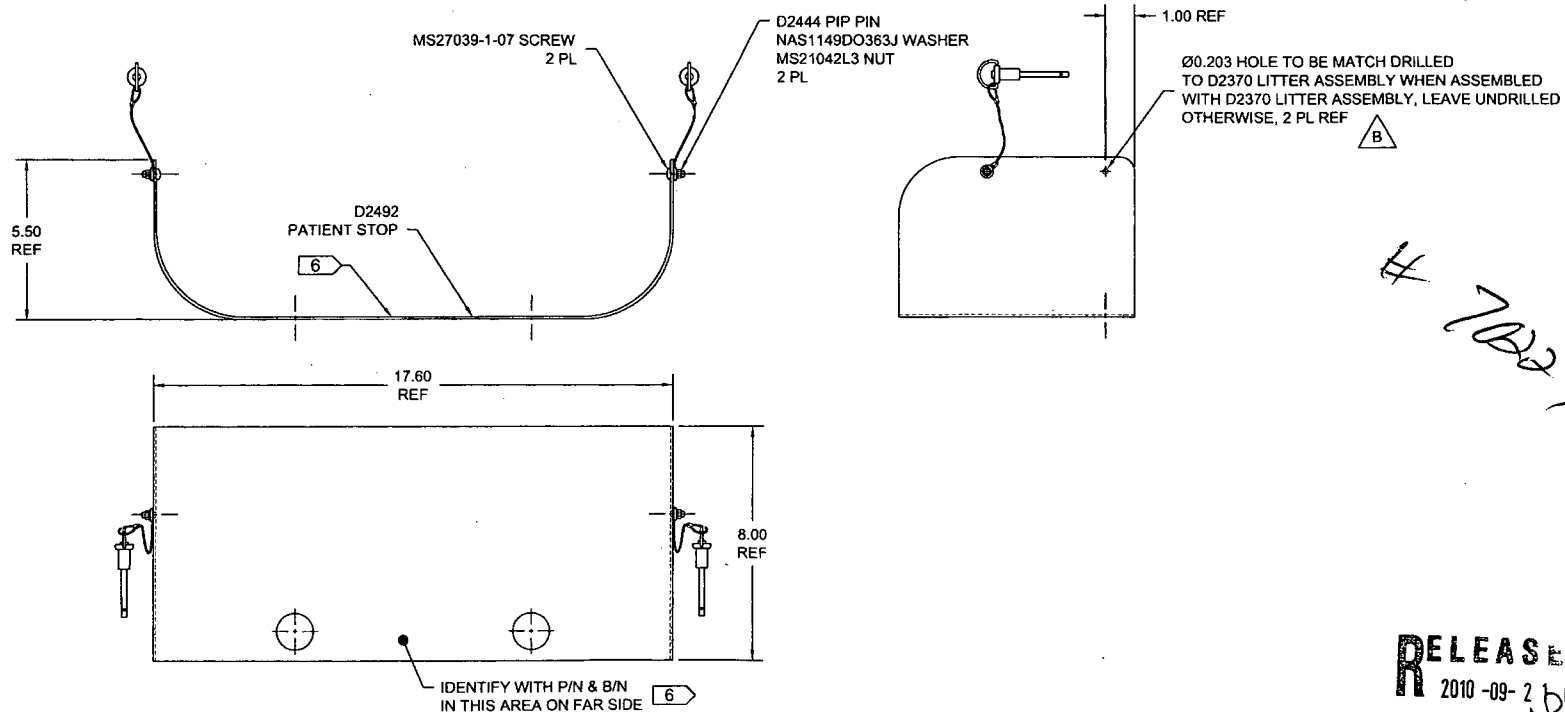
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D2493	PATIENT STOP ASSEMBLY
2	1	D2492	PATIENT STOP
3	2	D2444	PIP PIN
4	2	MS27039-1-07	SCREW
5	2	NAS1149DO363J	WASHER (OR AN960JD10)
6	2	MS21042L3	NUT (OR MS21042-3)



D2493 PATIENT STOP ASSEMBLY

NOTES:

- 1) MATERIAL: SEE PARTS LIST
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2493" AND B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 1.7 lbs

RELEASE
2010-09-20

B	REDRAW, HOLE NOW DRILLED (D2-1, NCR10-062)	CP	10.08.10
A	NEW ISSUE	BW	95.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	13	DRAWING NO.	REV. B
MFG. APPR.	3	D2493	SHEET 1 OF 1
APPROVED	3	TITLE	SCALE
DE APPR.	3	PATIENT STOP ASSEMBLY	NTS
DATE	10.08.10	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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